

Work Order ID 67602 - 3

Monday, March 28, 2011 2:27:30 PM

SPLIT 12  
D.H.P.



Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 11

Date: 4-03-12

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 ( Dwg Rev: C ) Prog Rev: C 12.  
Deburr if necessary

11-4-8

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-4-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Supplies

11-4-8

POSITIVE RECALL

RECEIVED

RELEASED

DATE 4-04-12

# Work Order ID 67602

Monday, March 28, 2011 2:27:30 PM



Page 2

Item ID: D3290-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

x18

Thermoforming Machine

Without removing protective skin! remove sharp edge by degurring

11/04/11

140



THERMOFORMING MACHINE

0.00

Thermoform

Memo

0.00

x18

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 □ Dwg.  
Rev. C □ Folio Rev B □ 2-Engrave part# &  
batch# (D3290-3)

11/04/11

150



QC2- Inspect parts off machine FAU/FAIB

0.00

QC

Memo

0.00

x78

Quality Control

11/04/11

# Work Order ID 67602

Monday, March 28, 2011 2:27:30 PM



Page 3

Item ID: D3290-3

Accept



Setup Start



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Stop



Item Name: Window

Start Date: 3/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11 04 18

170

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches if required

11/04/11

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Setup/11

415

Monday, March 28, 2011 2:27:30 PM

Accept

Setup Start

**Stop**

Cust Item ID:

Customer:

**Reference:**

Run Start

**Stop**

Insp.  
Stamp

0.00

## Memo

took 6 windows for w/o B6G998

0.00

0.00

## Memo

0.00

QC

### Quality Control



# Picklist Print

Monday, March 28, 2011 2:27:37 PM

Page 1

Work Order ID: 67602

Parent Item: D3290-3

Parent Item Name: Window



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A 04.08.18 New issue [KJ/RP]  
 IPP B 06.05.09 Ecn 798 EC  
 IPP C 07.05.29 Thermoform in-house DL  
 IPP D 07.09.28 rev C dwg EC verified by: DD  
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 		Purchased	No			100	sf	10.0000	3	<del>382</del> 37.89474	64		
1/8" Polycast II Sheet										KB11-4-8			

Location

Loc Qty

Loc Code

MAT019

10

115338

10

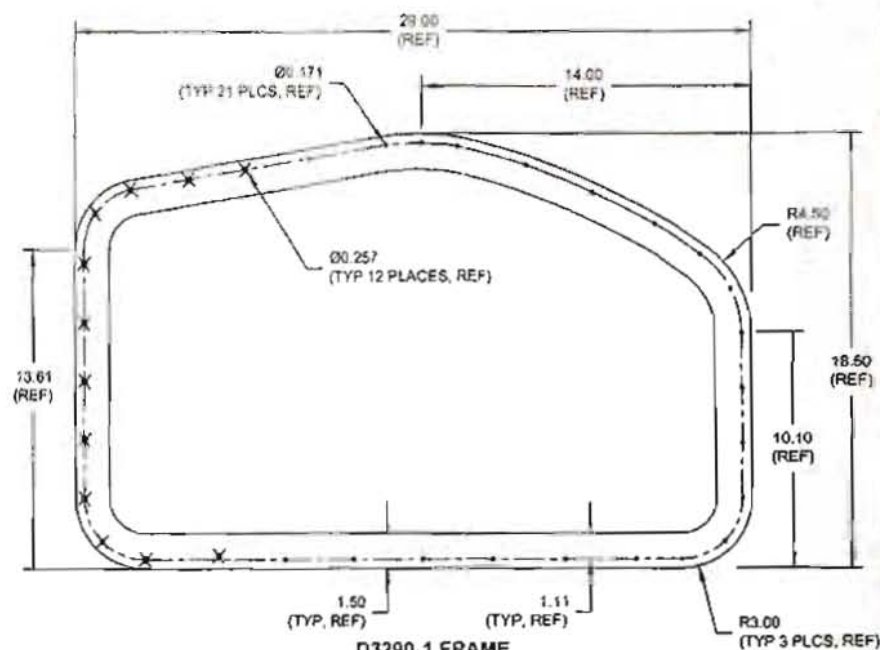
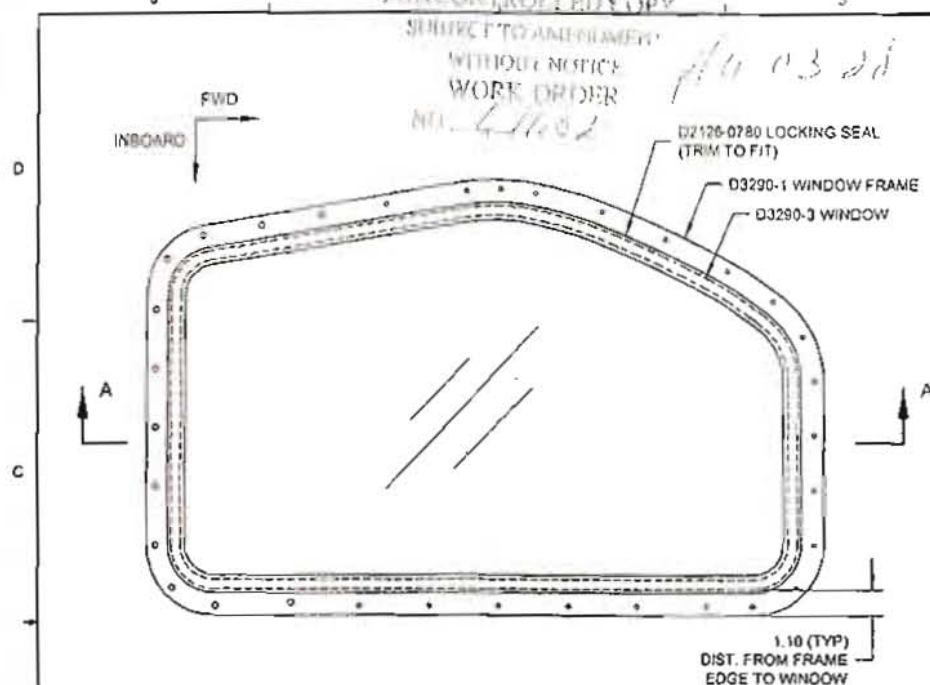
117340

117340

(18)



NO. 4402



D3290-1 FRAME

## D3290-1 NOTES:

- 1) MATERIAL: 8081-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER OSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART OSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS
- RELEASED  
07.09.88  
DEO ATTACH

RELEASED  
07.07.22

DEO ATTACHED

### D3290-041 REPLACEMENT WINDOW ASSEMBLY

## C3290-041 NOTES:

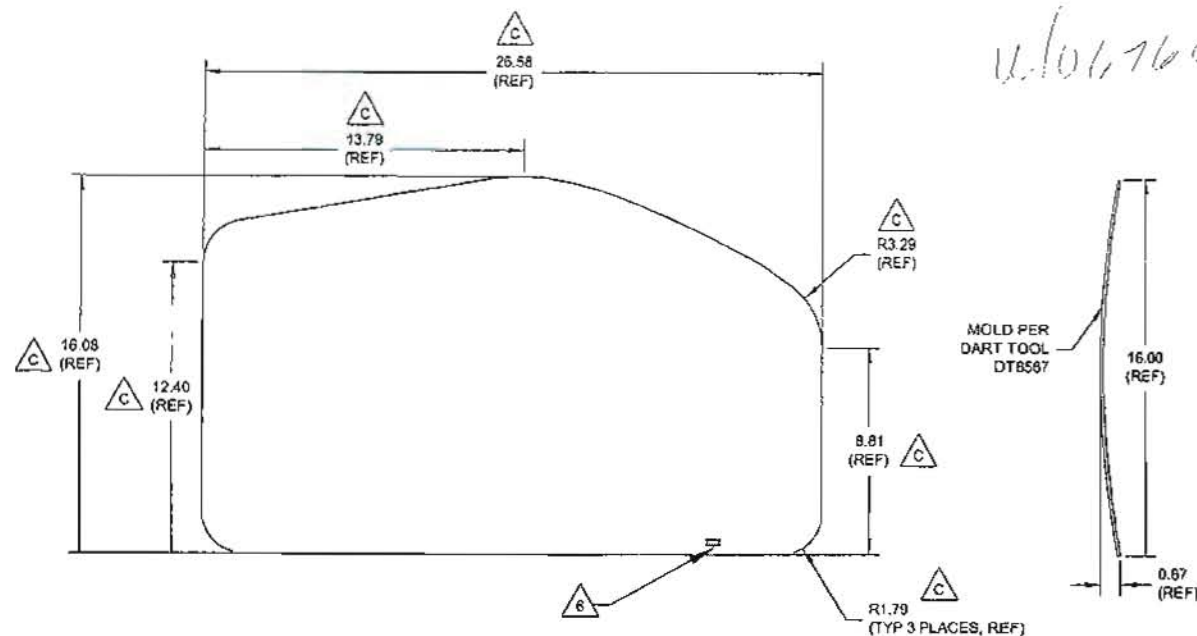
- 1) WEIGHT: 3.66 LBS

**GENERAL NOTE**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED

**UNDER REVIEW**

C	UPDATE DIMS PER PAR 158	DC	07.07.24
B	UPDATE MATERIAL PER NCM 028	MB	08.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG APPR		D3200	SHEET 1 OF
APPROVED		TITLE	SCALE
IE APPR	REPLACEMENT WINDOW ASSEMBLY		
DATE	07.07.24		



**D3290-3 WINDOW**

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425  
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER  
LP-391 TYPE 1 GRADE C, 0.125 THICK  
(REF. DART SPEC. M-ACRYLIC-S 125)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) REMOVE SHARP EDGES
  - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE  
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
  - 7) WEIGHT: 1.87 +/- 0.42 LBS
  - 8) MOLD PER DART TOOL DT8567

**UNDER REVIEW**

**DEO ATTACHED  
RELEASED**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	



DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED 1	MFG. APPR. E	APPROVED AD		DE APPR. H		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

**PURPOSE:**

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

**CHANGE:**

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

*u/c 47602*

**D3290-1 NOTES**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)  
 OR  
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/8 OR AMS 4016  
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

**RELEASED**  
 2009 -10- 09  
*WNT*

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